

# CLEAR COAT VOC/C

## CLB-03.006

### CHARACTERISTICS:

Ultra high solid clear coat with very good flow and high thixotropic properties. UV- and scratch-resistant. Designed for use on solvent- and waterborne base coats.

### APPLICATION:

Measure out the A+B mixture by volume: 2 parts of clear coat (A) and 1 part of hardener (B), then mix thoroughly. Apply with a spray gun with a nozzle diameter of 1.2 mm in 2 normal coats with a 7-10-minute break for the solvents to evaporate before applying another coat. To improve application properties, it is recommended to use thinner for acrylic products of up to 10% vol. on component A.

### TECHNICAL DATA:

**VOC 2004/42/IIB(d)(420) max. 420 g/l**

#### Clear coat CLB-03.006:

Shelf-life: 18 months      Density (20°C): 0.98 – 0.99 g/cm<sup>3</sup>      Colour: colourless/slightly yellow

#### Hardener standard CDL-04.003/ fast CDL-04.005/ very fast CDL-04.009/ slow CDL-04.006/ very slow CDL-04.031:

Shelf life: 12 months      Density (20°C): 1.00 – 1.05 g/cm<sup>3</sup>      Colour: colourless/slightly yellow

**NOTE:** Possible light colouration of the hardener doesn't affect the shade of the finishing coat.

#### Thinner standard CDL-07.002/ fast CDL-07.017/ slow CDL-07.015:

Shelf life: 24 months      Density (20°C): 0.80 – 0.90 g/cm<sup>3</sup>      Colour: colourless

#### Top Gloss Additive (gloss stabilizer) CDL-07.024:

Shelf life: 24 months      Density (20°C): 0.85 – 0.87 g/cm<sup>3</sup>      Colour: colourless

MIXING RATIO					
		<b>by volume</b>	<b>by weight</b>		
	<b>Clear coat (A)</b>	2	100		
	<b>Hardener (B)</b>	1	51 (standard) 52 (fast, very fast) 53 (slow, very slow)		
	<b>Thinner (C) or Top Gloss Additive (C)</b>	0 - 10% vol. on component A 5 - 8% vol. on component A	0 - 9% wt. on component A 4.4 - 7% wt. on component A		
SPRAY VISCOSITY					
	<b>DIN cup 4 mm at 20°C</b> <b>Ford cup 4mm at 20°C</b> <b>ISO cup 4 mm at 20°C</b>	18 - 22 s 19 - 23 s 42 - 50 s			
APPLICATION					
	<b>Spray gun gravity feed</b>	<b>nozzle</b>	<b>pressure</b>		
		1.2 mm	operating pressure as recommended by the spray gun manufacturer		
	<b>Application process</b>	<b>coats number</b>	<b>flash-off time</b>		<b>dry film thickness</b>
			<b>between coats</b>	<b>before baking</b>	
		2	7 - 10 min	10 min	50 - 55 µm
<b>Recommended process conditions</b>		temperature 18 - 22°C, relative air humidity 40 - 60%			
<b>Theoretical coverage</b>		10 - 11 m <sup>2</sup> /l			

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<b>Pot life at 20°C</b>	35 min with hardener standard CDL-04.003 30 min with hardener fast CDL-04.005 20 min with hardener very fast CDL-04.009 50 min with hardener slow CDL-04.006 60 min with hardener very slow CDL-04.031
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<b>DRYING TIMES</b>				
	Object temperature Hardener type	60°C	20°C	Full hardness at 20°C
		Dry to polish		
	standard CDL-04.003	30 min	10 h	7 days
	fast CDL-04.005	20 - 25 min	8 h	
	very fast CDL-04.009	10 - 15 min	6 h	
	slow CDL-04.006	45 min	12 h	
	very slow CDL-04.031	50 min	16 h	
NOTE: Prior to polishing the clear coat dried at 60°C, wait up to 1 h for cooling down.				
	<b>IR drying</b>	Short and medium wave: 12 - 15 min Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying.		

### REMARKS:

Allow the product to reach the recommended application temperature naturally (avoid rapid heating/cooling). It is not recommended to apply the product in a temperature below 18°C. Low application temperature changes the characteristics of the coating finish (increased open time, greater structure, longer curing time). Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20°C.

### STORAGE AND TRANSPORTATION CONDITIONS:

Protect from freeze, heat, sunlight and moisture. Store tightly closed in a dry, cool place.  
 Recommended storage temperature: +10 to +30°C.